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DAS
21
9-88

D2353
Job Sheet 202911



Part No: D2353

Job Qty: 10 pcs

Part Name: Stiffener



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/5/19

Job Tracking No:

Due Date: 12/18/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP Rev: A Removed from 9 Digit 05-11-10 EC IPP: B 06.11.15 waterjet EC IPP: c 06.12.07 ecn 836 ec

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	10 pcs	12/18/19	12/18/19	0.17	0.62	Waterjet - Flow		α 20/04/19
120	QC 8	10 pcs	12/18/19	12/18/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
							QC 8 - 76		
							QC 8 - 61		
130	Small Fab - Brake NC - B4B	10 pcs	12/18/19	12/18/19	0.25	0.38	Small Fab - Brake - 1 - B4B		

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				Small Fab - Brake - 2 - B4B	
				Small Fab - Brake - 3 - B4B	APR 16 2020
140 QC 5	10 pcs	12/18/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
150 Handfinish - 1-1 Chemical-B4B	10 pcs	12/18/19	0.00 0.42	Handfinish - 1 - 1 - B4B	BEB 20-04-17
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
155 QC 7	10 pcs	12/18/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				Plex 11/5/19 10:52 AM Dart.lajeunesse.marie	

					QC 7 - 17		
					QC 7 - 18		
					QC 7 - 19		
					QC 7 - 2		
					QC 7 - 28		
					QC 7 - 3		
					QC 7 - 30		
					QC 7 - 34	20-04-20	DAS 34 9-89
					QC 7 - 36		
					QC 7 - 37		
					QC 7 - 41		
					QC 7 - 47		
					QC 7 - 48		
					QC 7 - 51		
					QC 7 - 58		
					QC 7 - 59		
					QC 7 - 60		
					QC 7 - 9		
					QC 7 - 68		
					QC 7 - 50		
					QC 7 - 67		
					QC 7 - 40		
					QC 7 - 24		
					QC 7 - 43		
					QC 7 - 61		
					QC 7 - 81		
					QC 7 - 76		
					QC 7 - 79		
160	Powdercoat - 4 Black Sand - B4B	10 pcs	12/18/19	0.00 0.15	Powdercoat - 1 - B4B		
					Powdercoat - 2 - B4B		
					Powdercoat - 3 - B4B	20-04-20	DAS 34 9-89
					Powdercoat - 4 - B4B		
170	QC 3	10 pcs	12/18/19	0.00 0.00	QC 3 - 10		
					QC 3 - 13		
					QC 3 - 15		
					QC 3 - 17		
					QC 3 - 18		
					QC 3 - 2		
					QC 3 - 28		
					QC 3 - 3		
					QC 3 - 30		
					QC 3 - 34		
					QC 3 - 36		
					QC 3 - 41		
					QC 3 - 51		
					QC 3 - 58		
					QC 3 - 59	3EB2020-04-20	DAS 59 9-89
					QC 3 - 68		
					QC 3 - 9		
					QC 3 - 40		
					QC 3 - 19		
					QC 3 - 43		
					QC 3 - 24		
					QC 3 - 61		
					QC 3 - 81		
180	Packaging 3-1 - Stock - B4B	10 pcs	12/18/19	0.00 0.00	Packaging 3 - 1 - B4B		
					Packaging 3 - 2 - B4B		
					Packaging 3 - 3 - B4B		
					Packaging 3 - 4 - B4B		

				Packaging 3 - 5 - B4B					
				Packaging 3 - 6 - B4B					
				Packaging 3 - 7 - B4B					
				Packaging 3 - 8 - B4B					
				Packaging 3 - 9 - B4B					
				Packaging 3 - 10 - B4B					
				Packaging 3 - 11 - B4B					
				Packaging 3 - 12 - B4B					
				Packaging 3 - 13 - B4B					
				Packaging 3 - 14 - B4B					
				Packaging 3 - 15 - B4B					
				Packaging 3 - 16 - B4B					
				Packaging 3 - 17 - B4B					
				Packaging 3 - 18 - B4B					
				Packaging 3 - 19 - B4B					
				Packaging 3 - 20 - B4B					
				Packaging 3 - 21 - B4B					
				Packaging 3 - 22 - B4B	DAS				
				Packaging 3 - 23 - B4B	84				
				Packaging 3 - 24 - B4B	9-89				
				Packaging 3 - 25 - B4B					
				Packaging 3 - 26 - B4B					
				Packaging 3 - 27 - B4B					
				Packaging 3 - 28 - B4B					
				Packaging 3 - 29 - B4B					
				Packaging 3 - 30 - B4B					
				Packaging 3 - 31 - B4B					
				Packaging 3 - 32 - B4B					
				Packaging 3 - 33 - B4B					
				Packaging 3 - 34 - B4B					
				Packaging 3 - 35 - B4B					
				Packaging 3 - 36 - B4B					
				190 QC 21 - SA	10 pcs	12/18/19	0.00 0.00	QC 21 - SA - 21	
								QC 21 - SA - 70	DAS
								QC 21 - SA - 53	21

STJDS A

APR 21 2020

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.050	2024-T3 .050 Sheet	1.4630 sf (.1463 ea)	100-Waterjet - Flow - 1	S23739.2

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M2024T3S.050	1	26	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Stiffener	15.198Inches $\pm$ 0.010	15.208 15.188		
2	Stiffener	0.966Inches $\pm$ 0.005	0.971 0.961		
3	Stiffener	0.354Inches $\pm$ 0.010	0.364 0.344		
4	Stiffener	0.128Inches + 0.005 - 0.000	0.133 0.128		

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Container No: S270496



Part: D2353

Job No: 202911

Serial No/Batch: S270496

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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